



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5159-1
Job Sheet 159249



Part No: D5159-1

Job Qty: 4 ea

Part Name: Rib



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 11/15/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP REV:A 14.10.03 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier Lead Time	
90	Start up Operation	4 Ea		11/14/17	0.00	0.00	Start Up Container	J.C.-L. 17-12-06
110	Cold Saw	4 pcs		11/14/17	0.00	0.62	Cold Saw	J.C.-L. 17-12-06
120	Mill Conv	4 pcs		11/14/17	0.00	5.48	Mill Conv 1	J.C.-L. 17-12-07
130	QC	4 pcs		11/14/17	0.00	0.00	QC2	J.C.-L. 17-12-07
140	QC	4 pcs		11/14/17	0.00	0.00	QC8	FR 17-12-7
150	Powdercoat	4 pcs		11/15/17	0.00	0.08	Powdercoat3	DR 17-12-7
160	QC	4 pcs		11/15/17	0.00	0.00	QC3	17-12-7 JLM
170	Packaging	4 pcs		11/15/17	0.00	0.00	Packaging3	SB
180	QC21-SA	4 Ea		11/15/17	0.00	0.00	QC21	DAS 21 DEC 08 2017

Part Op 110 - CUT TO BLANK

Descriptions: 120 - DRILL HOLES AND MILL ENDS AS PER DWG ***ENSURE MATERIAL SEAM IS AT THE BOTTOM OF THE PART WHERE THERE IS NO HOLES***

150 - START TIME:

2:10 OUT: 3:20 FINISH: 2:40 M136370

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304TS0.750W.049	5	1,002	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Rib	14.700Inches ± 0.030	14.730 14.670		
2	Rib	12.790Inches ± 0.030	12.820 12.760		
3	Rib	0.950Inches ± 0.010	0.960 0.940		
4	Rib	0.266Inches ± 0.010	0.276 0.256		
5	Rib	0.297Inches ± 0.010	0.307 0.287		
6	Rib	0.400Inches ± 0.030	0.430 0.370		
7	Rib	1.000Inches ± 0.010	1.010 0.990		

DQA: _____ Date: _____
QA Closed: _____ Date: _____

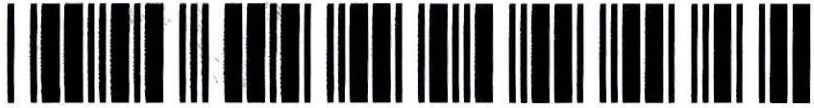
WORK ORDER NON-CONFORMANCE / UPDATE



Work Order update only

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____	Rework _____ Scrap _____ Use-as-is _____ Suspected Unapproved _____		Skid-tube _____ Machining _____ Thermoforming _____ Large Fab _____	Cross tube _____ Small Fab _____ Finishing _____ Composite _____	Water Jet _____ Prod. Eng. Coord. _____ Rec/Store/Packaging _____ Supplier _____	Engineering _____ Quality _____ Other _____
NCR No. _____	Step #: _____		MRB (QS1042) Approval _____			
Date: _____	QTY Effective: _____					

DART
AEROSPACE
S018211



Rib

PART NO:
Revision:
Operation:
Change No:

D5159 – 1

Start up Operation

Mfg Date: 12/06/17
Job No: 159249

Root Cause										FAULT																						
Environment	No Re-verification	Operator	Offset/Setup	Supplier	Training	Use for Testing	Poor Information	Rushing	Product Improvement	Process Improvement	Manufacturing Process	Past Due	Pressure/Forced	Bending	Centre Not Concentric	Cracks	Crimp/Kink/Ripple/Wave	Cuffs	Crushing	Heat Treat	Wave/Twist in Tube	Marks/Chatter	Temperature/Cure	Set-up	BOM/Route	Broken/Damage/Defect	Inspection Incomplete/Unqu	Contamination	Countersink	Cut Too Short	Instructions Incomplete/Unc	Drill Holes
Design																																
Doc/Data																																
Equip/Tooling																																
Handling/Pre																																
Material																																
Internal Transport																																
Tribal Knowledge																																
LOA																																
Substation																																
Past Expiry Date																																
Misidentified																																
													OTHER : _____																			

8	Rib	3.000Inches $\pm$ 0.010	3.010 2.990	
9	Rib	2.000Inches $\pm$ 0.010	2.010 1.990	
10	Rib	2.000Inches $\pm$ 0.010	2.010 1.990	
11	Rib	3.000Inches $\pm$ 0.010	3.010 2.990	
12	Rib	1.000Inches $\pm$ 0.010	1.010 0.990	
13	Rib	0.129Inches $\begin{matrix} + 0.005 \\ - 0.001 \end{matrix}$	0.134 0.128	
14	Rib	2.440Inches $\pm$ 0.030	2.470 2.410	
15	Rib	2.625Inches $\pm$ 0.010	2.635 2.615	
16	Rib	0.129Inches $\begin{matrix} + 0.005 \\ - 0.001 \end{matrix}$	0.134 0.128	
17	Rib	0.350Inches $\pm$ 0.030	0.380 0.320	Radius

Plex 12/6/17 1:52 PM dart.poulin.mario



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Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: M304TS0.750W.049 Revision: 304 Sq Tube .75X.75X.049W														
100	Receive Ft	S018207	159249	2 ft	0		Start Up Container		Stock	12/6/2017	Issue Container			
Operation Totals:		1		2	0									
Part Totals:		1		2	0									
Totals:		1		2	0									

Plex 1/8/2018 12:54 PM Dart.Boucher.Sylvie